

Date: Thursday, 6/7/2007 3:30:07 PM  
 User: Kim Johnston

## Process Sheet

*Sped up  
BB 07-11-02*

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB ASSEMBLY		
Job Number	: 32856~(					
Estimate Number	: 10194					
P.O. Number	:		Part Number	: D2174041		
This Issue	: 6/7/2007	S.O. No. :	Drawing Number	: D2174 REV E		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: E		
Previous Run	: 31651		Material	:		
Written By	:	<i>D 07-06-08</i>	Due Date	: 6/30/2007	Qty:	20 Um: Each
Checked & Approved By	<i>D 07-06-08</i>					
Comment	: Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM Est Rev:E As per Rev E 06-11-22 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D21741	Web	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Web			
	Qty Part Number	Description Batch	
	1 D2174-1	Web <i>D2174-08</i> B 35503	<i>mf</i>
2.0	D21751	Angle LH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Angle LH			
	Qty Part Number	Description Batch	
	1 D2175-1	Angle <i>D2175-1</i>	<i>mf</i>
3.0	D21752	Angle RH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Angle RH			
	Qty Part Number	Description Batch	
	1 D2175-2	Angle <i>D2175-2</i>	<i>mf</i>
4.0	MS20470AD46	Rivet, Universal Head	
Comment: Qty.: 19.0000 Each(s)/Unit Total : 380.0000 Each(s) Rivet, Universal Head			
	Qty Part Number	Description Batch	
	19 MS20470AD4-6	Rivet <i>M105408 x 306mx, M104118x74mx.</i>	<i>mf</i>

*mf 07-11-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
02/09/23		No Split into 2 WO	M/0	02/09/23	17		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:30:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 32856

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

mf 07-11-02

(20)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 21102

x20

7.0 POWDER COATING

POWDER COATING



M105914

Q20X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

mf 07/11/

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

Comment: INSPECT POWDER COAT

07-11-05

20x

9.0 AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Screw

Batch: M9216

AS

07/11/05

10.0 AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Batch: M104625

AS 07/11/05

11.0 MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Batch: M105430

AS 07/11/05

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

G 07/11/06 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:30:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 32856

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC5

INSPECT WORK TO CURRENT STEP



(cancel)

✓ A1116 (x20)

Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

6/11/06 EO

15.0 QC21

FINAL INSPECTION/W/O RELEASE



07.11.07 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

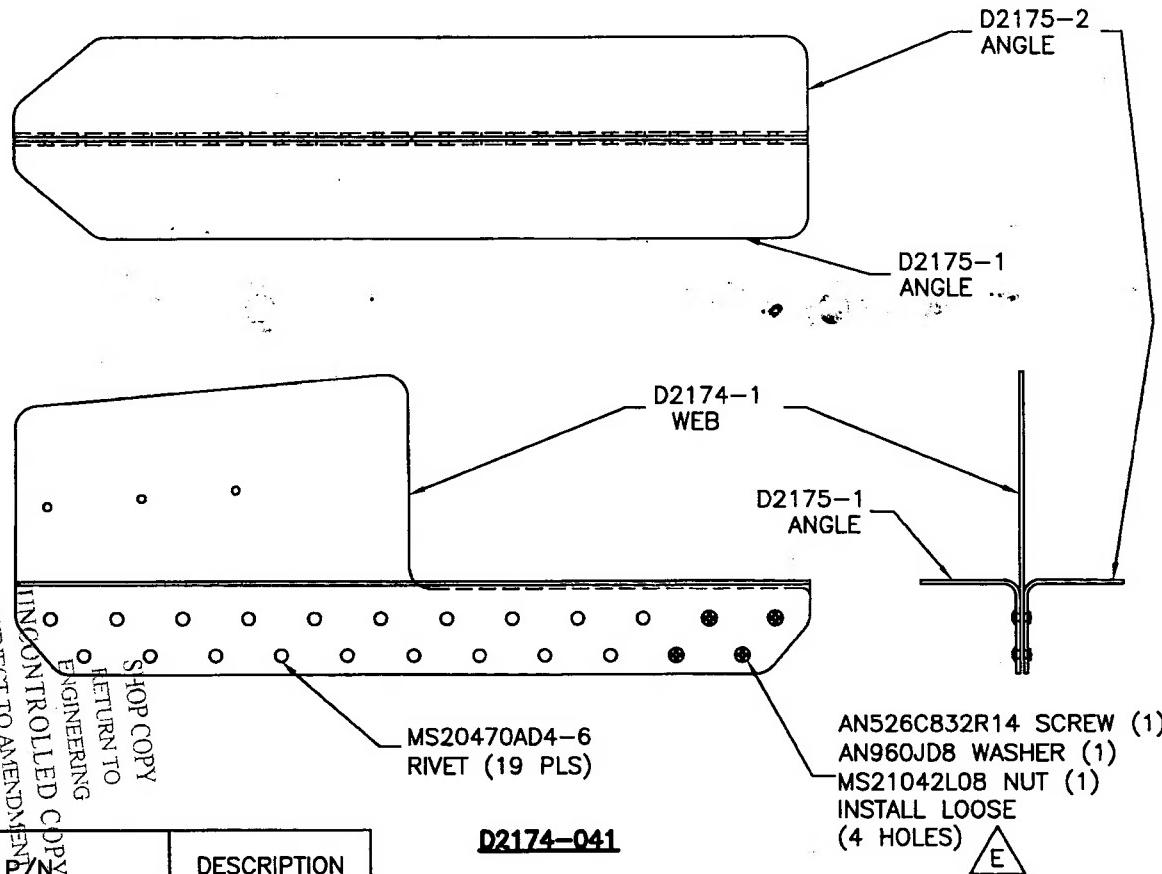
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>CH</i>	DRAWING NO. D2174	REV. E SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO $\phi$ 0.172; CHG HARDWARE	



QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

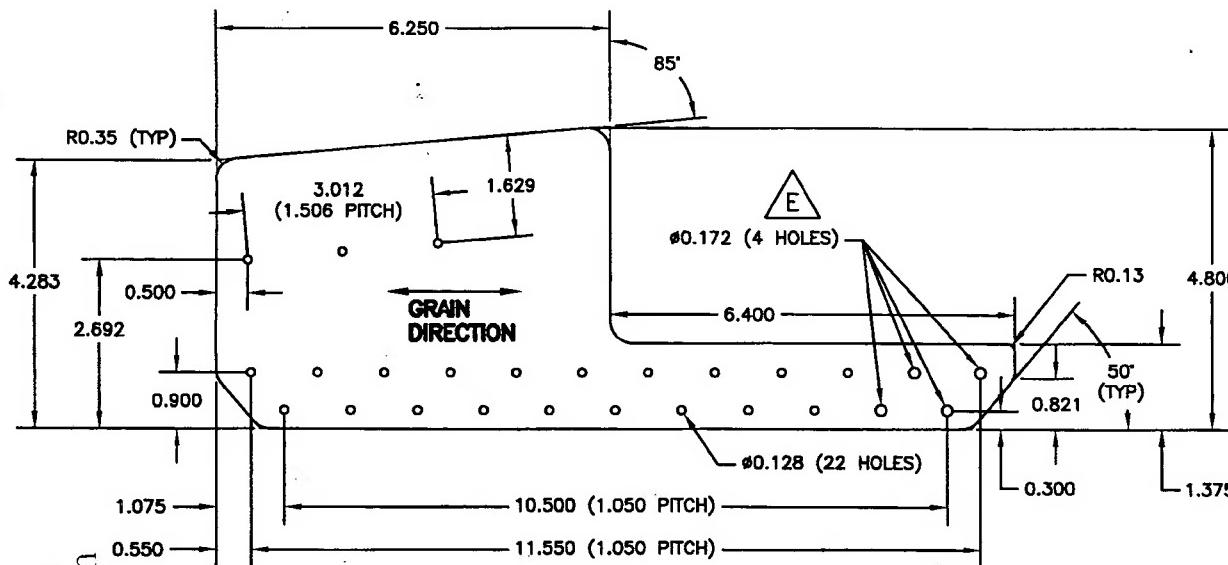
**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

**RELEASED**  
06.10.13

**DART**

DESIGN RF	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D2174
DATE 06.09.25		SCALE 1:3

**RELEASED**  
(6.10.3)**D2174-1**

SHOP COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. *30856*

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